

Date: Tuesday, 1/23/2007 7:31:26 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 6" MIRROR
Job Number	: 30376		
Estimate Number	: 10101		
P.O. Number	: <i>N/A</i>	Part Number	: D2011101
This Issue	: 1/23/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D2011 REV. F
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 29773	Drawing Revision	: F
	Type : SMALL /MED FAB	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 1/29/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	50 Um: Each
Comment	: Est: J 04.09.15 Added Steps 5-7 KJ/JLM		
	: Est: K 05.12.15 chg black sikaflex for white EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: *2929 C207101124* (50)
 Purchase Grote Mirror P/N: 28043
 Possible supplier: UAP/NAPA
 Material release note required

2.0	28043	MIRROR 6"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)
 Mirror 6"

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Recieve & Inspect for Transit Damage
 Ensure Material Release Note is attached

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

5.0	D30141	Locknut
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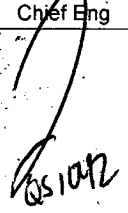
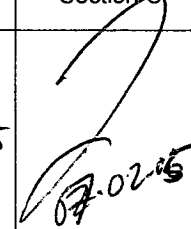
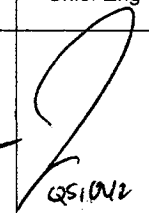
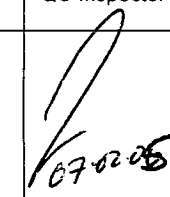


Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)
 Locknut
 Pick:
 Qty Part Number Description Batch
 1 D3014-1 Lock nut *m18605*

MF 07-02-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/02/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/02/05	7	1 minor broke when hole were drill		Scrap & destroy	SB 07/02/05			

NOTE: Date & initial all entries

Date: Tuesday, 1/23/2007 7:31:26 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 6" MIRROR

Job Number: 30376

Part Number: D2011101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN960JD416L

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

1 AN960JD416L Washer

M101237

MF 07-02-02

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Discard Hardware & Install new hardware loosely

MF 07-02-02

2- Drill mirror using drill Jig DT8704 as per Dwg D2011

MF 07-02-02

3- Inject 3ml of Sikaflex -291/-241 adhesive per hole.

Qty Part Number Description Batch
9ml N/A Sikaflex-291/-241

Batch
M100672
Expiry date
02/07

MF 07-02-02

Start: 1:05 Time: 1:05

Finish: 07/02/02 Time: 7:30

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

4- Test assembly to 50lbs pull test after 24 hours

SP 07/02/05

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5199

07/02/05 49

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/02/06

Job Completion



07/02/06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

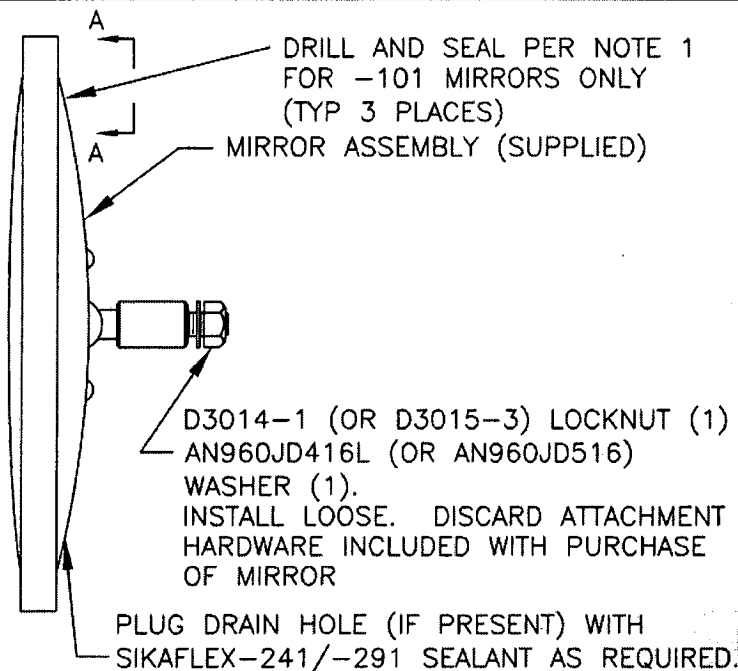
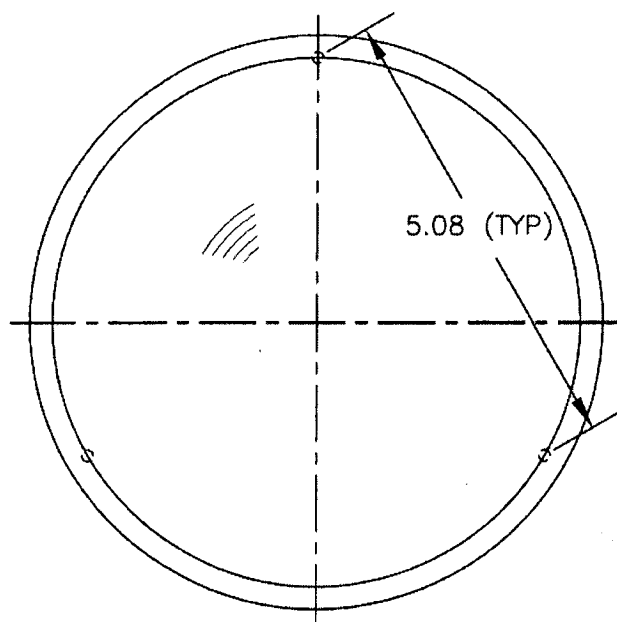
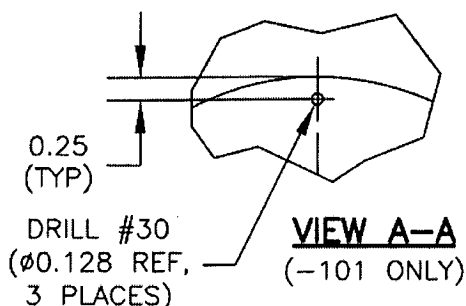
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2011	REV. F SHEET 1 OF 1
DATE 04.09.10		TITLE MIRROR ASSEMBLY	SCALE 1:2
-	90.03.31	NEW ISSUE	
A	90.06.15	DWG No. WAS DSP1011, ADDED -103	
B	98.04.09	SIKAFLEX 241 ADDED	
C	99.06.01	REPLACE DOMINION AUTO MIRRORS WITH PHILLIPS, ADDED STUDS, REDRAWN	
D	01.04.23	NEW 6" MIRROR, ADD NUT, RMV STUD	
E	01.05.08	NEW 8" MIRROR	
F	04.09.10	ADD HOLES FOR SEALANT ON -101	



RELEASED
04.09.10

QTY -101	QTY -103	Part Number	Description
X		D2011-101	MIRROR ASSEMBLY 6"
	X	D2011-103	MIRROR ASSEMBLY 8"
1		28043	MIRROR 6" (GROTE)
1	1	708441	MIRROR 8" (VELVAC)
1		D3014-1	LOCKNUT
	1	AN960JD416L	WASHER
	1	D3015-3	LOCKNUT
	1	AN960JD516	WASHER

NOTES:

- 1) ON -101 MIRRORS ONLY, DRILL QTY(3) Ø0.128 HOLES (REF) AS SHOWN AND INJECT SIKAFLEX-241/-291 SEALANT TO ENSURE MIRROR ADHERES TO HOUSING. TEST ASSEMBLY TO 50 LBS AFTER 24 HOURS.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30376

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HAWKESBURY AUTO PARTS INC 5580GST#: 861597896RT0001
4 MAIN STREET WEST EXC#:SU 6259 EXP:03/12/31
HAWKESBURY, ONT. K6A 2J2
TEL:632-8575 FAX: 632-1539

DANGEROUS GOODS PERMIT
EXPIRY DATE:

EMERGENCY TELEPHONE NUMBER 24 HOURS
CANUTEC 613-996-6666

ACCT #	SOLD TO	DATE	TIME	STORE #	EMP #	INVOICE NO.
01601	DART AEROSPACE LTD 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7	1/29/07	14:20	060004074	31	148348
SR #		PURCHASE ORDER #				ATTENTION
E		6122-5207				
AD		TAX EXEMPTION:				
E4		TERMS: NET 30 DAYS				CHARGE SALE
		DELIVERY:				

PART NUMBER	LN	DESCRIPTION	QUANTITY	PRICE	NET	TOTAL
28043	GRD	GRUTE	50.00	41.140	16.820	841.00

REFUNDED BY _____

Subtotal 841.00
Tax 6% GST ONLY 50.46
Tax 0% 0.00

VERIFIED BY _____

Emile Baucher
SIGNATURE

ALL GOODS RETURNED MUST BE ACCOMPANIED BY THIS INVOICE

TOTAL ----> CHARGE SALE 891.46

Comments:		Tax Summary:		Less:			
		GST	50.46	included tax		0.00	
		GSTME	0.00	Subtotal		841.00	
		GSTND	0.00	Total tax		50.46	
Entered By: CL CLAVOIE		Approved By: _____		Total purchase order in			
				CAD Dollars		891.46	